

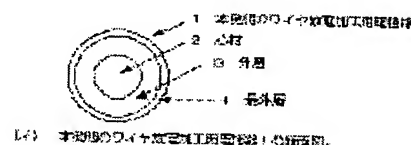
ELECTRODE WIRE FOR WIRE ELECTRIC DISCHARGE MACHINING

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- european:
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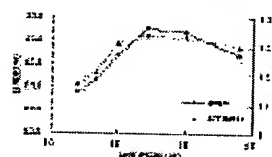
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Abstract of JP2002137123

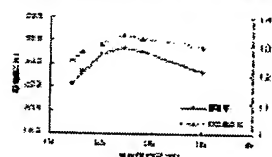
PROBLEM TO BE SOLVED: To provide an electrode wire for wire electric discharge machining capable of realizing a higher speed than a conventional electrode wire to reduce machining cost. **SOLUTION:** In this electrode wire for wire electric discharge machining in which a core member is made of copper zinc alloy containing zinc of 15 to 30 wt.%, an outer layer 3 is formed with a thickness of 6% or more of a finish outside diameter of high zinc brass having zinc concentration of 48 to 68 wt.% on a surface of the core member, and a zinc covered layer is provided with a thickness of 0.5 to 2% of a total finish outside diameter as an outermost layer 4 at its outer periphery furthermore, it is possible to realize a higher machining speed at which a workpiece is cut by 20% or more than the conventional wire when, in particular, a dielectric constant of the electrode wire calculated according to an calculation expression of electrode wire dielectric constant becomes 23% or more, preferably, it becomes 29% or more in the case of copper alloy when the core member contains zinc of 15 wt.%, and it becomes 27% or more in the case of copper alloy when the core member contains zinc of 20 wt.%, and it becomes 24% or more in the case of copper alloy when the core member contains zinc of 30 wt.%.



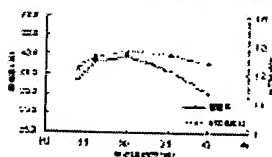
(イ) 本発明のワイヤ放電加工用電極線1の断面図。



(ロ) 本発明のワイヤ放電加工用電極線1の断面図。電極線の断面図に於ける高亜鉛黄銅層の厚さと高亜鉛黄銅層の組成との関係を示す図。



(ハ) 本発明のワイヤ放電加工用電極線1の断面図。電極線の断面図に於ける高亜鉛黄銅層の厚さと高亜鉛黄銅層の組成との関係を示す図。



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